

Date: Wednesday, 15/08/2007 3:46:16 PM  
 User: Linda Lacelle

## Process Sheet

Customer : CU-DAR001 Dart Helicopters  
 Job Number : 33905  
 Estimate Number : 11224  
 P.C. Number : N/A  
 This Issue : 15/08/2007 S.O. No. : N/A  
 Prsht Rev. : NC  
 First Issue : N/A Type : SMALL / MED FAB  
 Previous Run : 32798  
 Part Number : D206547043  
 Drawing Number : D206-547 REV F  
 Project Number : N/A  
 Drawing Revision : F  
 Material : N/A  
 Due Date : 31/08/2007 Qty: 10 Um: Each  
 Written By :  
 Checked & Approved By :  
 Comment : Est Rev: 06-01-05 Removed Packing Kit JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2024 Extrusion, Console



Comment: Qty.: 3.5910 Each(s)/Unit Total: 35.9100 Each(s)

D2024 Extrusion

Batch M1

FF 07-09-16 10

2.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut D2710-1, D2710-2, D2710-3, D2710-4 from D2024 Extrusion as per Dwg D2710 and templates DT 8264-1, DT 8264-2, DT8264-3, DT8264-4

2-Deburr

FF 07-09-16 10

3.0 D26021 Console Side Hi Slope



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2602-1

Side LH

~~B32819~~

~~x1~~

~~B33906~~

~~x7~~

~~B23311~~

~~x2~~

FF 07-09-17 10

4.0 D26022 Console Side Hi Slope



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2602-2

Side RH

~~B33907~~

FF 07-09-17 10

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: D206-547-043 PAR #: N/A Fault Category: Prod / Prod. Ass <sup>MAINT. SUPPLY</sup> NCR: Yes / No DQA: 12 Date: 07/11/16  
 QA: N/C Closed: 10 Date: 07.11.16

| NCR: <u>33905</u> |      | WORK ORDER NON-CONFORMANCE (NCR)            |                              |                                 |                |                           |                              |                          |
|-------------------|------|---|------------------------------|---------------------------------|----------------|---------------------------|------------------------------|--------------------------|
| DATE              | STEP | Description of NC<br>Section A              | Corrective Action Section B  |                                 |                | Verification<br>Section C | Approval<br>Chief Eng        | Approval<br>QC Inspector |
|                   |      |   | Initial<br>Chief Eng         | Action Description<br>Chief Eng | Sign &<br>Date |                           |                              |                          |
| 07/09/16          | 2    | D2710-1 cut to short<br><br>RC Hammer error | <i>[Signature]</i><br>Resian | scrap and Destroy               | FF<br>07/09/24 | Er<br>07/09/24            | <i>[Signature]</i><br>Resian | Er<br>07/09/24           |
|                   |      |   |                              |                                 |                |                           |                              |                          |
|                   |      |   |                              |                                 |                |                           |                              |                          |

NOTE: Date & initial all entries

Date: Wednesday, 15/08/2007 3:46:17 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CONSOLE ASSEMBLY

Job Number: 33905

Part Number: D206547043

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

|     |       |                    |
|-----|-------|--------------------|
| 5.0 | D2606 | Hi Console Bracket |
|-----|-------|--------------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2606

Bracket

B31334

FF 07-09-17

10

|     |       |                 |
|-----|-------|-----------------|
| 6.0 | D2607 | Console Bracket |
|-----|-------|-----------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2607

Bracket

B33909

FF 07-09-17

10

|     |             |                       |
|-----|-------------|-----------------------|
| 7.0 | MS20470AD33 | Rivet, Universal Head |
|-----|-------------|-----------------------|



Comment: Qty.: 8.0000 Each(s)/Unit Total: 80.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 MS20470AD3-3

Rivet

M1065

FF 07-09-20

10

|     |             |                       |
|-----|-------------|-----------------------|
| 8.0 | MS20470AD34 | Rivet, Universal Head |
|-----|-------------|-----------------------|



Comment: Qty.: 20.0000 Each(s)/Unit Total: 200.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

20 MS20470AD3-4

Rivet

M15541

FF 07-09-20

10

|     |             |                               |
|-----|-------------|-------------------------------|
| 9.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-----|-------------|-------------------------------|



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Grind weld relief chamfer as per Dwg D206-547

2-Rivet extrusion to sides as per Dwg D206-547 using Rivet MS20470AD3-4

FF 07-11-08

FF 07-09-20

FF 07-09-24

10

10

10

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

Date: Wednesday, 15/08/2007 3:46:17 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CONSOLE ASSEMBLY

Job Number: 33905

Part Number: D206547043

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/09/25

center  
10 LH  
x 10 RH

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Tack weld as per Dwg D206-547

A/R AL ROD Batch: M10156

PD 07-09-26

(10)

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/10/08

x 10 LH  
x 10 RH

13.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/11/09

(10)

14.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Rivet sides and brackets per Dwg D206-547 using Rivet MS20470AD3-3.

FF 07/11/15

(10)

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/11/15 (10)

16.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3.

M102316

07/11/15

10X

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07-11-15

(10)

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Wednesday, 15/08/2007 3:46:17 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CONSOLE ASSEMBLY

Job Number: 33905

Part Number: D206547043

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*Cc 7/11/16*

*(10)*

19.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*D 07/11/16*

Job Completion



*u 07.11.16*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

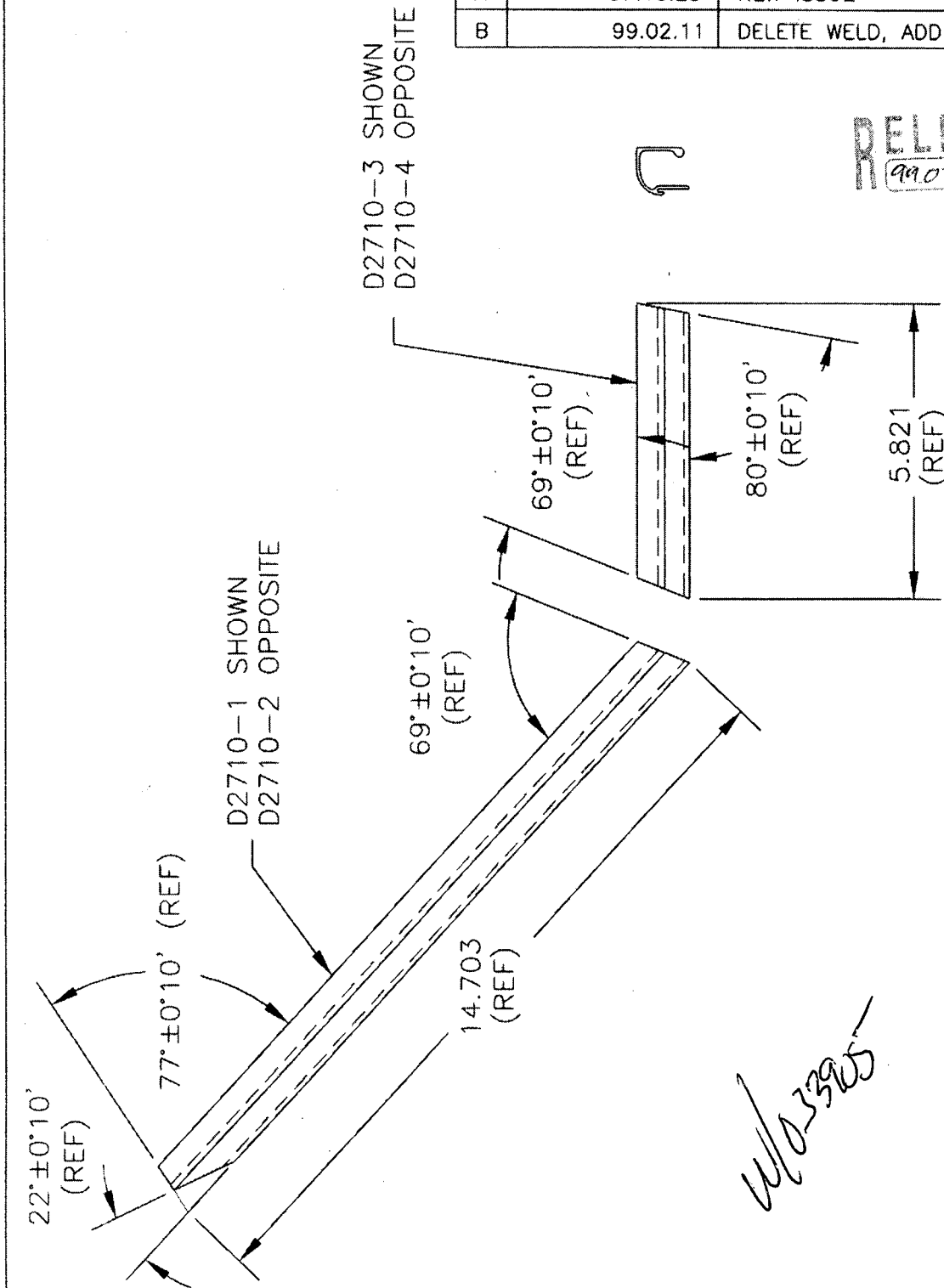
NOTE: Date & initial all entries





|                  |                |   |                        |
|------------------|----------------|---|------------------------|
| DESIGN<br>BW     | DRAWN BY<br>RF | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br>CP    | APPROVED<br>KE | DRAWING NO.<br>D2710                              | REV. B<br>SHEET 1 OF 1 |
| DATE<br>99.02.11 |                | TITLE<br>CONSOLE SIDE RAIL                        | SCALE<br>1:3           |
| A                | 97.10.25       | NEW ISSUE   |                        |
| B                | 99.02.11       | DELETE WELD, ADD TEMPL. (TSR A1020)               |                        |

RELEASED  
99.07.05 KE



MATERIAL: MAKE FROM D2024 EXTRUSION  
MAKE PER TEMPLATE # DT8264  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



|                      |                       |   |                        |
|----------------------|-----------------------|---|------------------------|
| DESIGN<br><b>BW</b>  | DRAWN BY<br><b>RF</b> | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA                                 |                        |
| CHECKED<br><b>CP</b> | APPROVED<br><b>KE</b> | DRAWING NO.<br>D206-547   | REV. F<br>SHEET 1 OF 5 |
| DATE<br>99.02.11     |                       | TITLE<br>CONSOLE ASSEMBLY<br>SCALE<br>NTS   |                        |
| -                    | 82.11.23              | NEW ISSUE   |                        |
| A                    | 83.01.18              | REDRAWN, ADD NOTE 4   |                        |
| B                    | 84.10.23              | D206-547 WAS 01.B.81.017  |                        |
| C                    | 89.03.30              | REDRAWN   |                        |
| D                    | 90.12.06              | COMPANY NAME CHANGE<br>MS20470 WAS MS20426<br>DIM 1.312 WAS 1.0, 13.160 WAS 12.85 |                        |
| E                    | 97.10.22              | REDRAWN, ADD -043, -045, -047   |                        |
| F                    | 99.02.11              | ADD MS20470AD3-3 RIVET (NC 143)<br>UPDATED WELD DETAIL                            |                        |

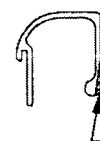
RELEASED  
99.03.05 RE

| -041 | -043 | -045 | -047 | PART NUMBER  | DESCRIPTION       |
|------|------|------|------|--------------|-------------------|
| X    |      |      |      | D206-547-041 | CONSOLE ASSEMBLY  |
|      | X    |      |      | D206-547-043 | CONSOLE ASSEMBLY  |
|      |      | X    |      | D407-547-045 | CONSOLE ASSEMBLY  |
|      |      |      | X    | D407-547-047 | CONSOLE ASSEMBLY  |
| 1    |      |      |      | D2601-1      | CONSOLE SIDE      |
| 1    |      |      |      | D2601-2      | CONSOLE SIDE      |
|      | 1    |      |      | D2602-1      | CONSOLE SIDE      |
|      | 1    |      |      | D2602-2      | CONSOLE SIDE      |
|      |      | 1    |      | D2603-1      | CONSOLE SIDE      |
|      |      | 1    |      | D2603-2      | CONSOLE SIDE      |
|      |      |      | 1    | D2604-1      | CONSOLE SIDE      |
|      |      |      | 1    | D2604-2      | CONSOLE SIDE      |
| 1    |      | 1    |      | D2605        | CONSOLE BRACKET   |
|      | 1    |      | 1    | D2606        | CONSOLE BRACKET   |
| 1    | 1    |      |      | D2607        | CONSOLE BRACKET   |
|      |      | 1    | 1    | D2608        | CONSOLE BRACKET   |
| 1    |      | 1    |      | D2709-1      | CONSOLE SIDE RAIL |
| 1    |      | 1    |      | D2709-2      | CONSOLE SIDE RAIL |
| 1    |      | 1    |      | D2709-3      | CONSOLE SIDE RAIL |
| 1    |      | 1    |      | D2709-4      | CONSOLE SIDE RAIL |
|      | 1    |      | 1    | D2710-1      | CONSOLE SIDE RAIL |
|      | 1    |      | 1    | D2710-2      | CONSOLE SIDE RAIL |
|      | 1    |      | 1    | D2710-3      | CONSOLE SIDE RAIL |
|      | 1    |      | 1    | D2710-4      | CONSOLE SIDE RAIL |
| 10   | 8    | 8    | 6    | MS20470AD3-3 | RIVET             |
| 18   | 20   | 18   | 20   | MS20470AD3-4 | RIVET             |

4/0  
33905

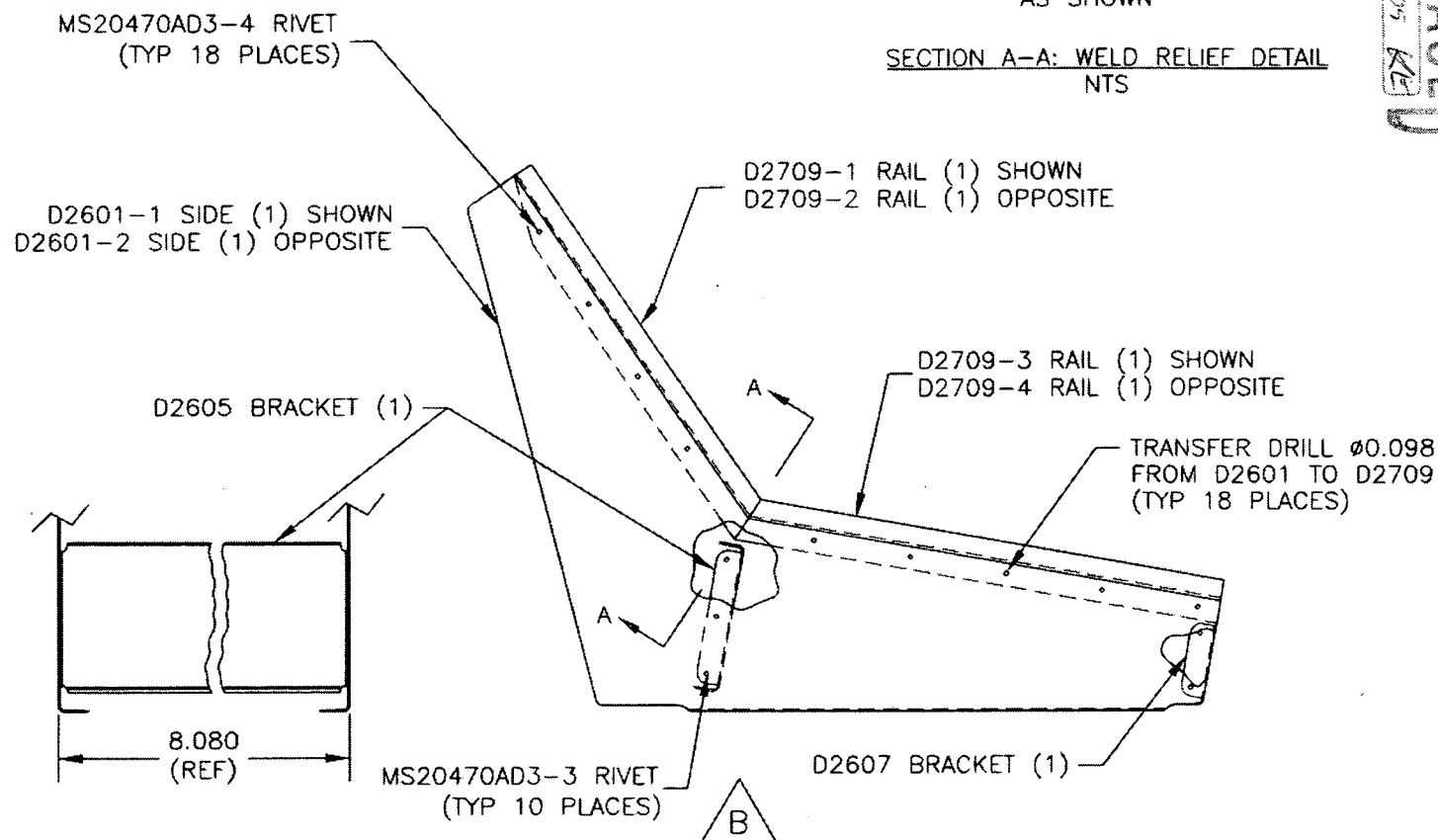
**DART**

RELEASED  
940305 KE



GRIND RELIEF  
CHAMFER FOR WELD  
0.040-0.050 x 45°  
AS SHOWN

SECTION A-A: WELD RELIEF DETAIL  
NTS



D206-547-041 (206 LOW SLOPE CONSOLE)

FINISH: POWDER COAT ASSEMBLY MATTE BLACK (4.3.5.4) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

| DESIGN   | DRAWN BY | TITLE                       |
|----------|----------|-----------------------------|
| BW       | RF       | DART AEROSPACE LTD          |
| CHECKED  | APPROVED | HAWKESBURY, ONTARIO, CANADA |
| KE       | KE       | D206-547                    |
| DATE     |          | REV. F                      |
| 99.02.11 |          | SHEET 2 OF 5                |
|          |          | SCALE                       |
|          |          | 1:4                         |

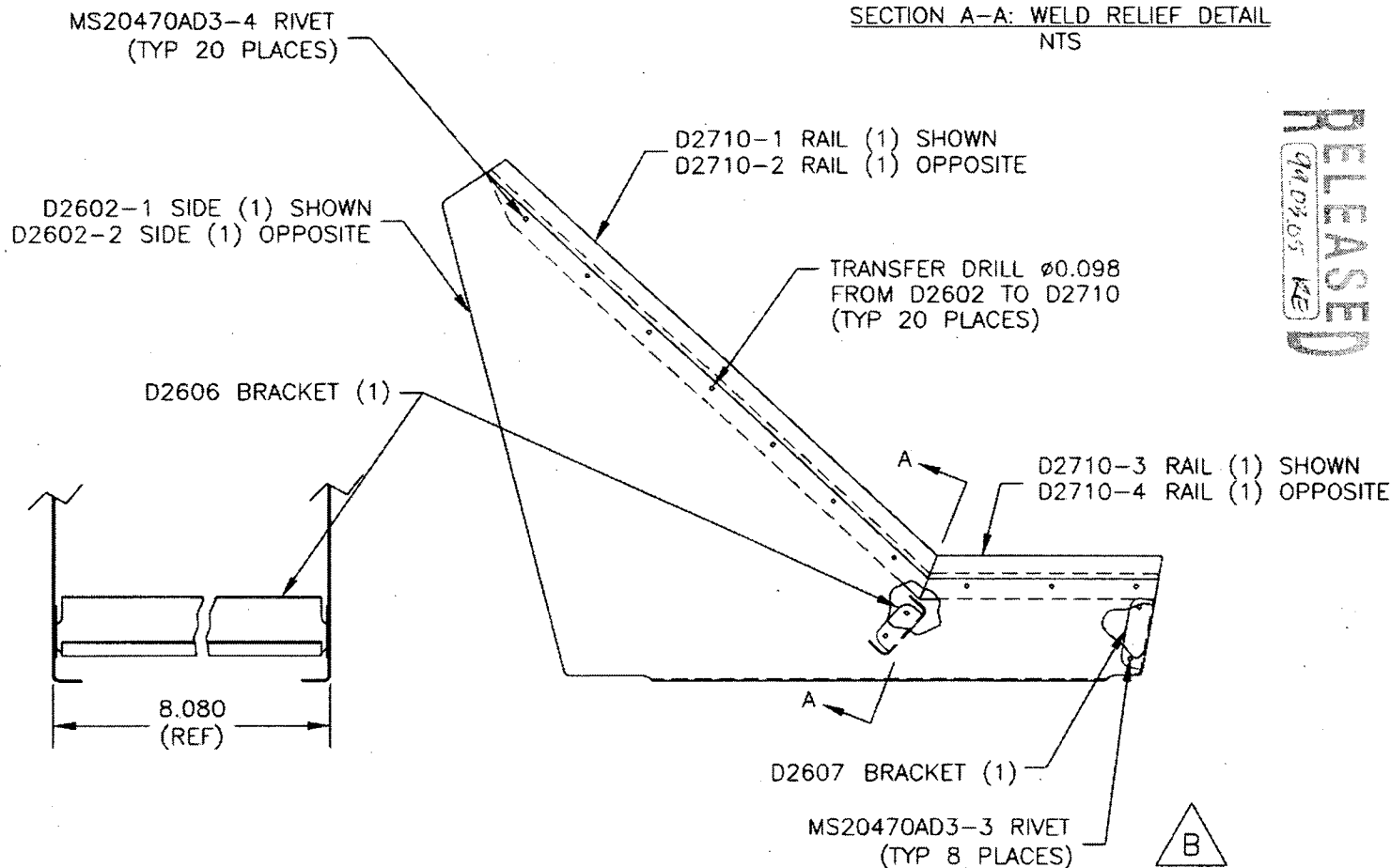
**DART**

RELEASED  
990305 KE



GRIND RELIEF  
CHAMFER FOR WELD  
0.040-0.050 x 45°  
AS SHOWN

SECTION A-A: WELD RELIEF DETAIL  
NTS



D206-547-043 (206 HIGH SLOPE CONSOLE)

FINISH: POWDER COAT ASSEMBLY MATTE BLACK (4.3.5.4) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

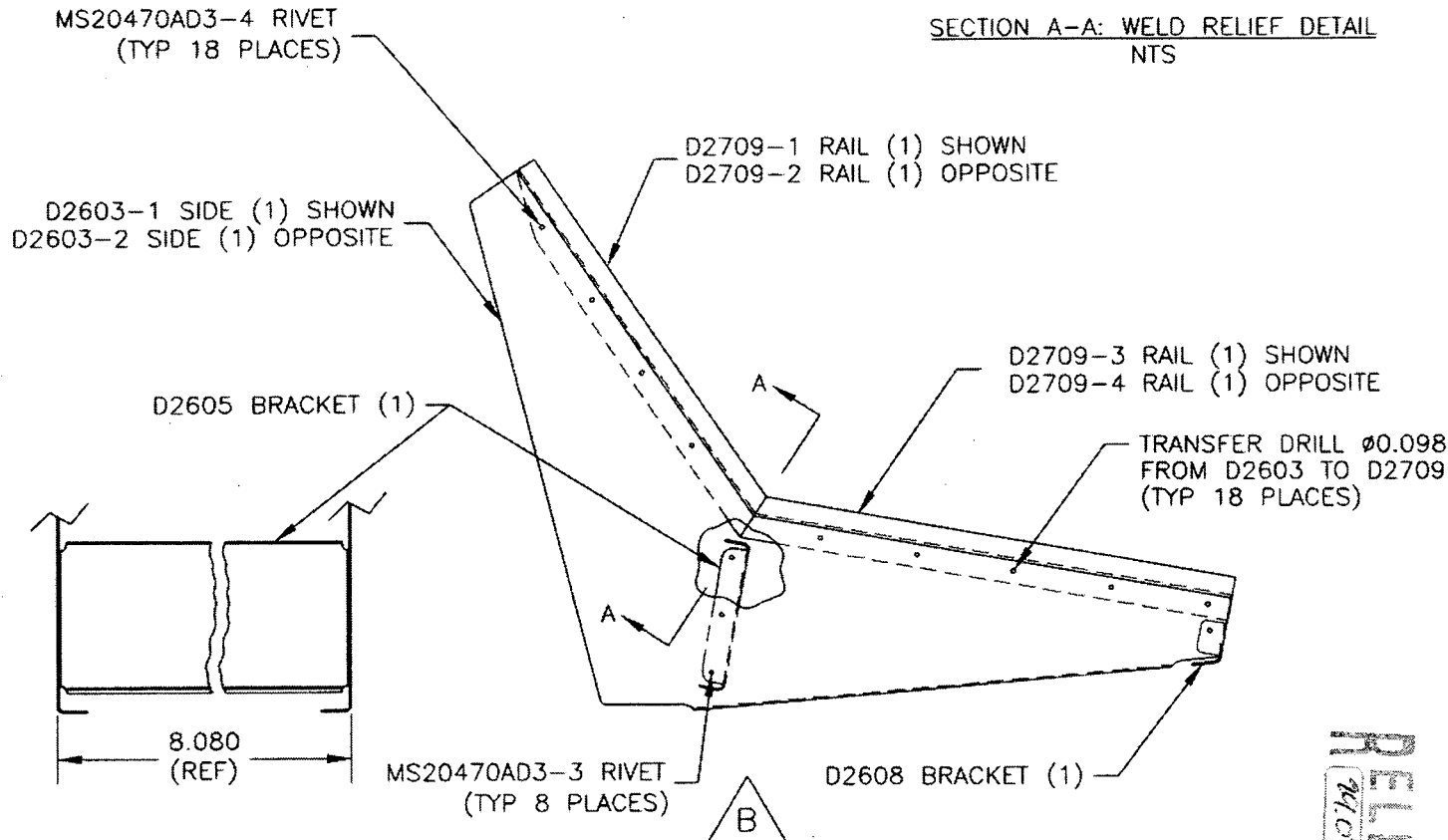
|                  |                           |   |
|------------------|---------------------------|---|
| DESIGN<br>B W    | DRAWN BY<br>R F           | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |
| CHECKED<br>UP    | APPROVED<br>KE            | DRAWING NO.<br>D206-547                           |
| DATE<br>99.02.11 | TITLE<br>CONSOLE ASSEMBLY | REV. F<br>SHEET 3 OF 5                            |
|                  | SCALE<br>1:4              |   |

**DART**



GRIND RELIEF  
CHAMFER FOR WELD  
0.040-0.050 x 45°  
AS SHOWN

SECTION A-A: WELD RELIEF DETAIL  
NTS



D407-547-045 (407 LOW SLOPE CONSOLE)

FINISH: POWDER COAT ASSEMBLY MATTE BLACK (4.3.5.4) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED  
140305 RE

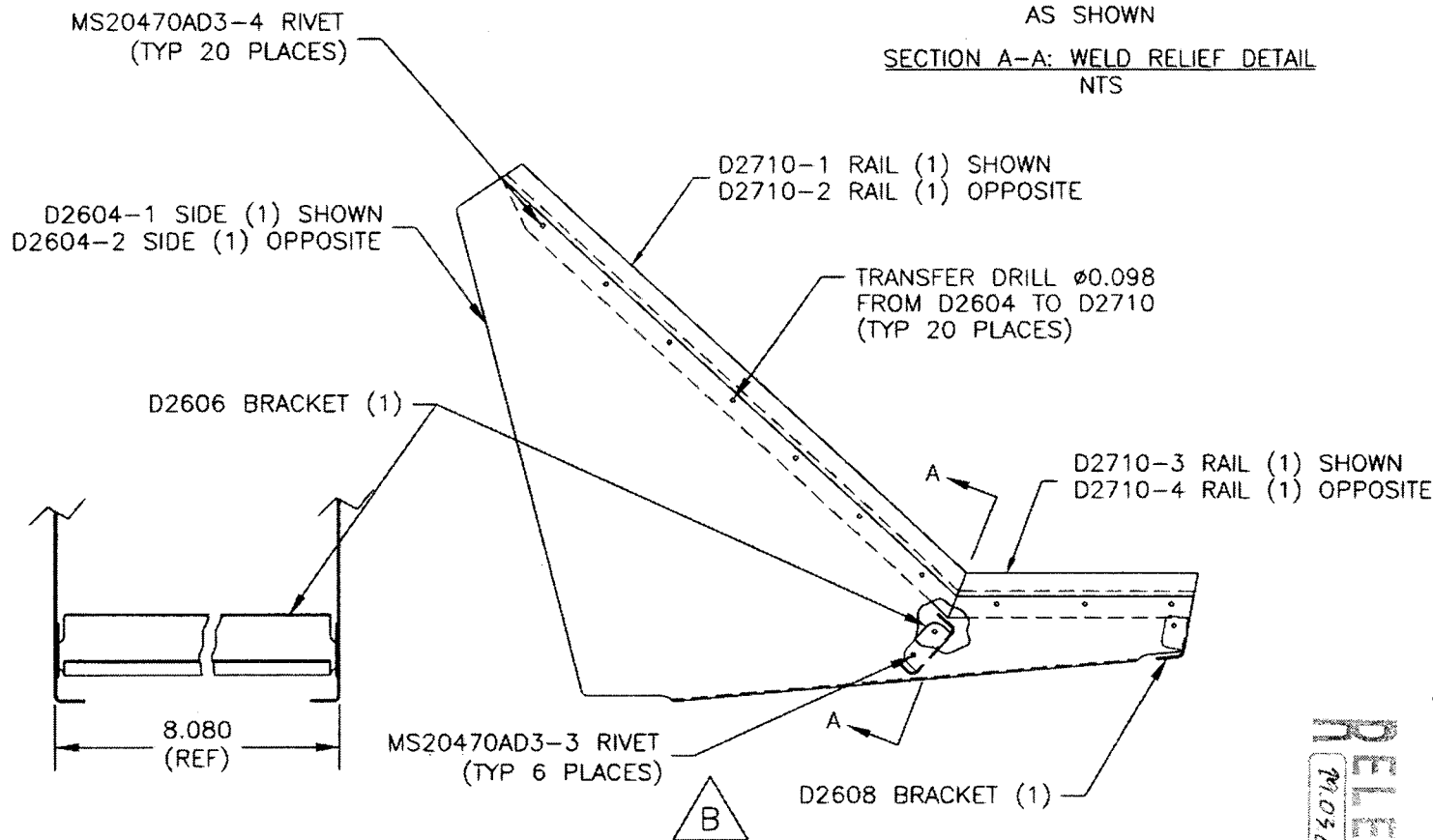
|                        |                           |  |
|------------------------|---------------------------|--|
| DESIGN<br>BW           | DRAWN BY<br>RF            | DART AEROSPACE LTD<br>HAMKSBURY, ONTARIO, CANADA |
| CHECKED<br>[Signature] | APPROVED<br>[Signature]   | DRAWING NO.<br>D206-547                          |
| DATE<br>99.02.11       | TITLE<br>CONSOLE ASSEMBLY | REV. F<br>SHEET 4 OF 5                           |
|                        | SCALE<br>1:4              |  |

**DART**



GRIND RELIEF  
CHAMFER FOR WELD  
0.040-0.050 x 45°  
AS SHOWN

SECTION A-A: WELD RELIEF DETAIL  
NTS



D407-547-047 (407 HIGH SLOPE CONSOLE)

FINISH: POWDER COAT ASSEMBLY MATTE BLACK (4.3.5.4) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED  
M0305 KLE

|         |          |             |                  |  |
|---------|----------|-------------|------------------|--|
| DESIGN  | BW       | DRAWN BY    | RF               | DART AEROSPACE LTD<br>HAMKSBURY, ONTARIO, CANADA |
| CHECKED | UP       | APPROVED    | KE               |  |
| DATE    | 99.02.11 | DRAWING NO. | D206-547         | REV. F   |
|         |          | TITLE       | CONSOLE ASSEMBLY | SHEET 5 OF 5                                     |
|         |          | SCALE       | 1:4              |  |